

Work Order ID 102550

May-30-13 1:50:04 PM

\*102550\*

Page 1

Item ID: D3957-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Hinge. Door LH Lower

Stop

\*NS2\*

Start Date: 5/30/13

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/06/13

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M65

Date: 5-30-13

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3957	A
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100	0.00
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\*100\*

Bandsaw

Memo

0.00

5-13-06-05

1 0

Jeaspa Bandsaw

cut blank to 3.200" long

110

\*110\*

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

1-Machine as per Folio FA839

FOLIO REV: AA

DWG REV: A

5-13-06-06

1 0

04  
08  
9-09

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework	<input type="checkbox"/>	Skid-tube	<input type="checkbox"/>	Crosstube	<input type="checkbox"/>	Water Jet	<input type="checkbox"/>	Engineering	<input type="checkbox"/>
NCR No. _____	Scrap	<input type="checkbox"/>	Machining	<input type="checkbox"/>	Small Fab	<input type="checkbox"/>	Prod. Eng. Coor.	<input type="checkbox"/>	Quality	<input type="checkbox"/>
	Use-as-is	<input type="checkbox"/>	Thermoforming	<input type="checkbox"/>	Finishing	<input type="checkbox"/>	Rec/Store/Packaging	<input type="checkbox"/>	Other	<input type="checkbox"/>
	Suspected Unapproved	<input type="checkbox"/>	Large Fab	<input type="checkbox"/>	Composite	<input type="checkbox"/>	Supplier	<input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear		General							
		Bending	<input type="checkbox"/>	Folio/Program	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>	Pressure/Forced	
		Centre Not Concentric	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Set-up	
		Cracks	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Temperature/Cure	
		Crimp/Kink/Ripple/Wave	<input type="checkbox"/>	Inspection Incomplete/Unqualified	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Weld	
		Cuffs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>	Wrong Stock Pulled	
		Crushing	<input type="checkbox"/>	Misaligned/off center	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>		
		Heat Treat	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>	Other	
		Inspection Strip in Tube	<input type="checkbox"/>	Misread	<input type="checkbox"/>		<input type="checkbox"/>		
		Marks/Chatter	<input type="checkbox"/>	Off-set	<input type="checkbox"/>		<input type="checkbox"/>		
Turning Sequence	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>				
Wave/Twist in Tube	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>				

Work Order ID 102550

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\*102550\*

Page 2

Item ID: D3957-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Hinge, Door LH Lower

Stop

\*NS2\*

Start Date: 5/30/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

Da 13/06/06

1

6

DAS  
08  
9-89

\*120\*

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

Da 13/06/06

1

0

\*130\*

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

1

0

\*140\*

HandFinish

Memo

0.00

Hand Finishing

1 76/13-6-7

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>		
NCR No. _____							

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions
Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>
Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>
Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>
Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>
Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>
Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>
Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>	
Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	
Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	
Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>		

Work Order ID 102550

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\*102550\*

Page 3

Item ID: D3957-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Hinge, Door LH Lower

Start Date: 5/30/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 <b>*150*</b> Powdercoat	White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum	0.00	Start Time: 8:00	Temp: 320°F	180	13/06/07			
Powder Coating	Memo MASK THREADED HOLE	0.00	Finish Time: 8:30						
160 <b>*160*</b> QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00							
170 <b>*170*</b> Packaging	Identify as per dwg & Stock Location: <u>6.A</u>	0.00							
Packaging	Memo	0.00							

*m125620*

*160 13/06/07*

*1 9 FF 13-06-07*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Suspected Unapproved			Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other						

Work Order ID 102550

May-30-13 1:50:04 PM

\*102550\*

Page 4

Item ID: D3957-3

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Hinge, Door LH Lower

Stop

\*NS2\*

Start Date: 5/30/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 6/06/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

13/6/11 JH

\*180\*

QC

Memo

0.00

ME  
13-6-1

Quality Control

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
	Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced				
	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up				
	Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure				
	Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld				
	Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled				
	Crushing	Countersink	Misaligned/off center	Positioned Wrong					
	Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge					
	Inspection Strip in Tube	Drawing	Misread						
	Marks/Chatter	Drill Holes	Off-set						
	Turning Sequence	Finish	Out of Calibration						
	Wave/Twist in Tube	Fit/Function	Out of Sequence						

# Picklist Print

May-30-13 1:50:08 PM

Page 1

Work Order ID: 102550

\*102550\*

Parent Item: D3957-3

\*D3957-3\*

Parent Item Name: Hinge, Door LH Lower

Start Date: 5/30/13

Required Date: 6/06/13

Start Qty: 1.00

Required Qty: 1.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X03.00 0		Purchased		No		100	f	16.1460	0.2666	0.280632			

\*M6061T6B0 750X03.000\*

6061-T6 Bar .750 x 3.00

\*\*

Location	Loc Qty	Loc Code
MAT049	16.146	
104741	4.146	
125272	12	

.281 on 13/06/05

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_

## DISPOSITION

 Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved 

## AGAINST DEPARTMENT/PROCESS

 Skid-tube   
 Machining   
 Thermoforming   
 Large Fab 

 Crosstube   
 Small Fab   
 Finishing   
 Composite 

 Water Jet   
 Prod. Eng. Coor.   
 Rec/Store/Packaging   
 Supplier 

 Engineering   
 Quality   
 Other 

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										

## FAULT CATEGORY

Landing Gear		General									
	Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced		
	Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up		
	Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure		
	Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld		
	Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
	Crushing		Countersink		Misaligned/off center		Positioned Wrong				
	Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge				
	Inspection Strip in Tube		Drawing		Misread						
	Marks/Chatter		Drill Holes		Off-set						
	Turning Sequence		Finish		Out of Calibration						
	Wave/Twist in Tube		Fit/Function		Out of Sequence						

DART AEROSPACE LTD		Work Order:	102508
Description: Hinge, Door LH Lower		Part Number:	D3957-3
Inspection Dwg: D3957	Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article  Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.69	+/-0.030	0.686	✓		Vern	6A-01
0.281	+/-0.010	0.281	✓		"	"
0.281	+/-0.010	0.281	✓		"	"
3.00	+/-0.030	2.985	✓		"	"
R0.13	+/-0.030	R0.125	✓		R-6	ref.
0.563	+/-0.010	0.562	✓		Vern	6A-01
1.25	+/-0.030	1.252	✓		"	"
1.93	+/-0.030	1.936	✓		"	"
107°	+/-0.5°	107°	✓		Angle M.	CNC-03
0.250	+/-0.010	0.251	✓		Vern	6A-01
<del>00.203</del>	<del>+0.005/-0.004</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>
<del>1.170</del>	<del>+/-0.010</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>
<del>0.30</del>	<del>+/-0.030</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>
<del>0.33</del>	<del>+/-0.030</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>	<del>—</del>
00.063	+0.004/-0.001	0.067	✓		Vern	6A-01
0.125	+/-0.010	0.122	✓		"	"
0.094	+/-0.010	0.090	✓		"	"
0.12	+/-0.030	0.150	✓		"	"
R0.50	+/-0.030	R0.500	✓		R-6	ref.

Measured by:	B.A	DA	Audited by:		Prototype Approval:	N/A
Date:	13/06/06	9-89	Date:	13-06-06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.11.13	New Issue	KJ	AA

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

Work Order update only 

Work Order: \_\_\_\_\_  
 Part No. \_\_\_\_\_  
 NCR No. \_\_\_\_\_

## DISPOSITION

Rework   
 Scrap   
 Use-as-is   
 Suspected Unapproved

## AGAINST DEPARTMENT/PROCESS

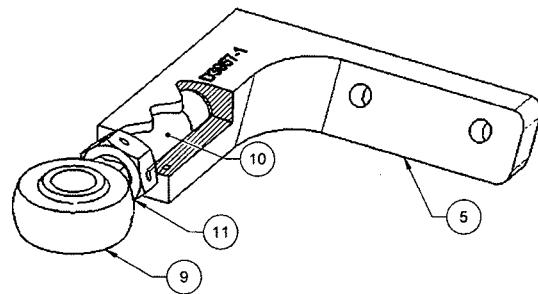
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

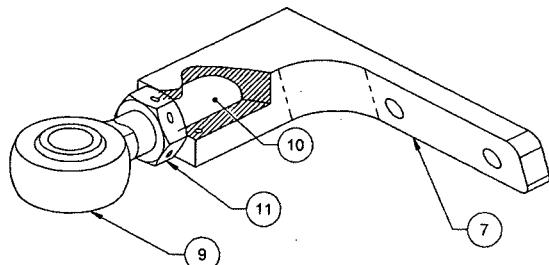
## FAULT CATEGORY

Landing Gear	General			
Bending	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		

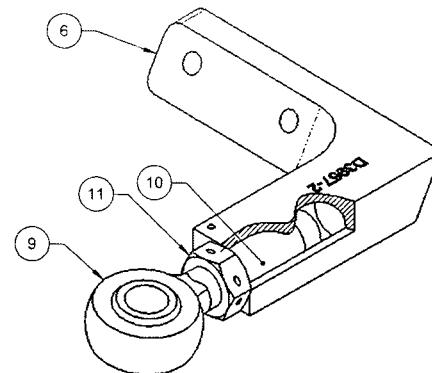
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELOCOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



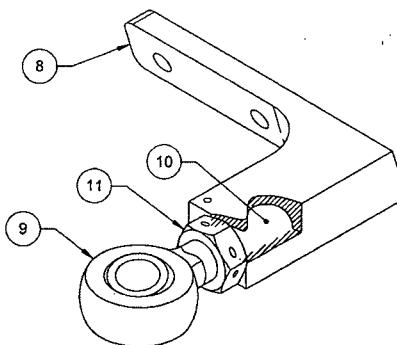
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
10255000  
13-05-30

RELEASED  
R 2009-10-03  
M

A	NEW ISSUE	09.09.03
REV.	BY	DATE
DESIGN	<i>AB</i>	DART AEROSPACE LTD
DRAWN	<i>AB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>AB</i>	REV. A
APPROVED	<i>AB</i>	D3957
DE APPR.	<i>AB</i>	SHEET 1 OF 5
DATE	09.09.03	TITLE
		HINGE
		NTS
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

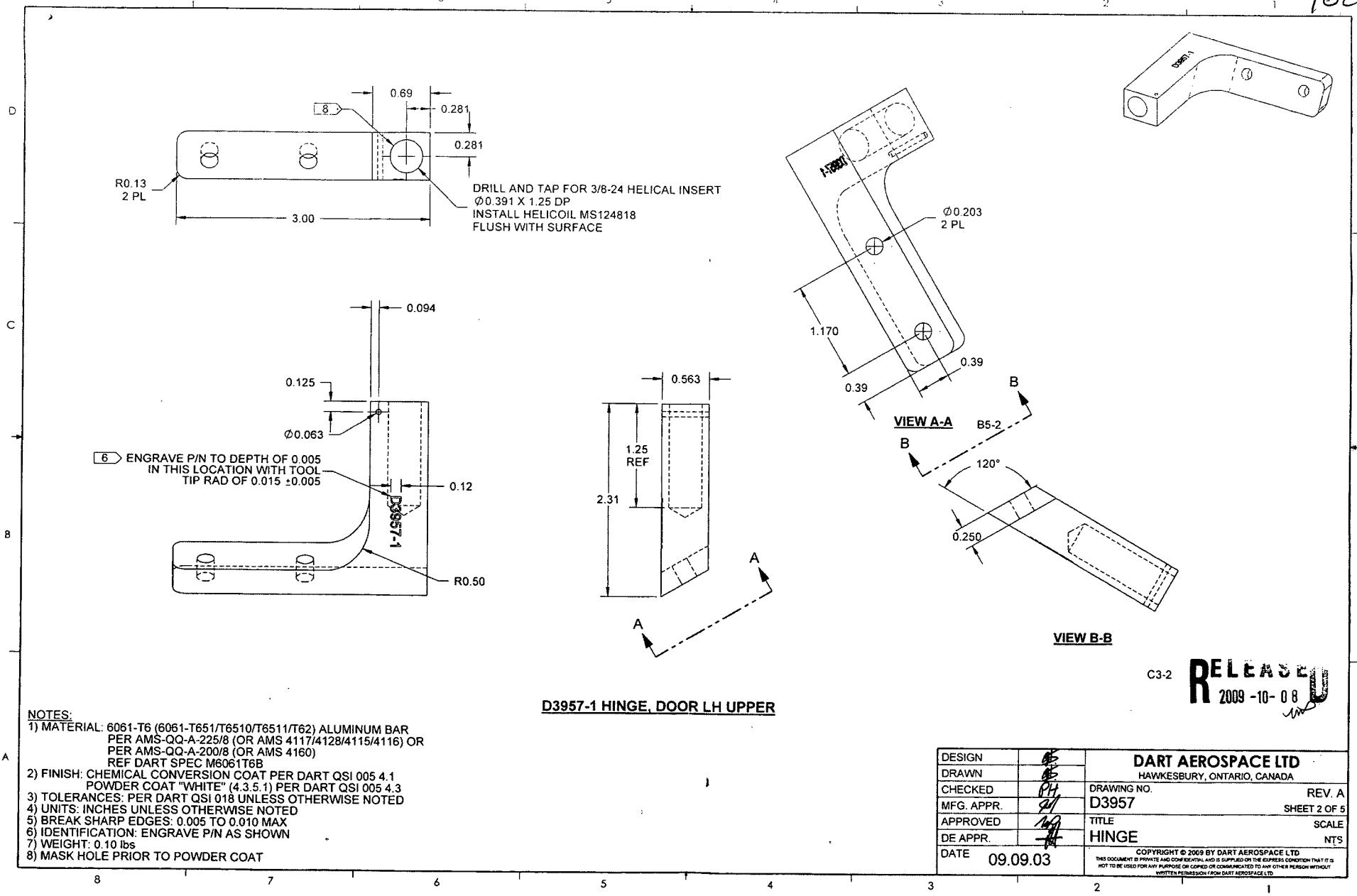
Work Order update only 

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

## FAULT CATEGORY

Landing Gear		General									
Bending		Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>		Pressure/Forced <input type="checkbox"/>					
Centre Not Concentric		BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>		Set-up <input type="checkbox"/>					
Cracks		Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>					
Crimp/Kink/Ripple/Wave		Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>		Weld <input type="checkbox"/>					
Cuffs		Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>					
Crushing		Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
Heat Treat		Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>		Other <input type="checkbox"/>					
Inspection Strip in Tube		Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>								
Marks/Chatter		Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>								
Turning Sequence		Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
Wave/Twist in Tube		Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								



C3-2 **RELEASE** **R** 2009-10-08

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	DRAWING NO.
MFG. APPR.	<i>[Signature]</i>	D3957
APPROVED	<i>[Signature]</i>	REV. A
DE APPR.	<i>[Signature]</i>	SHEET 2 OF 5
DATE	09.09.03	SCALE
		NTS

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## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

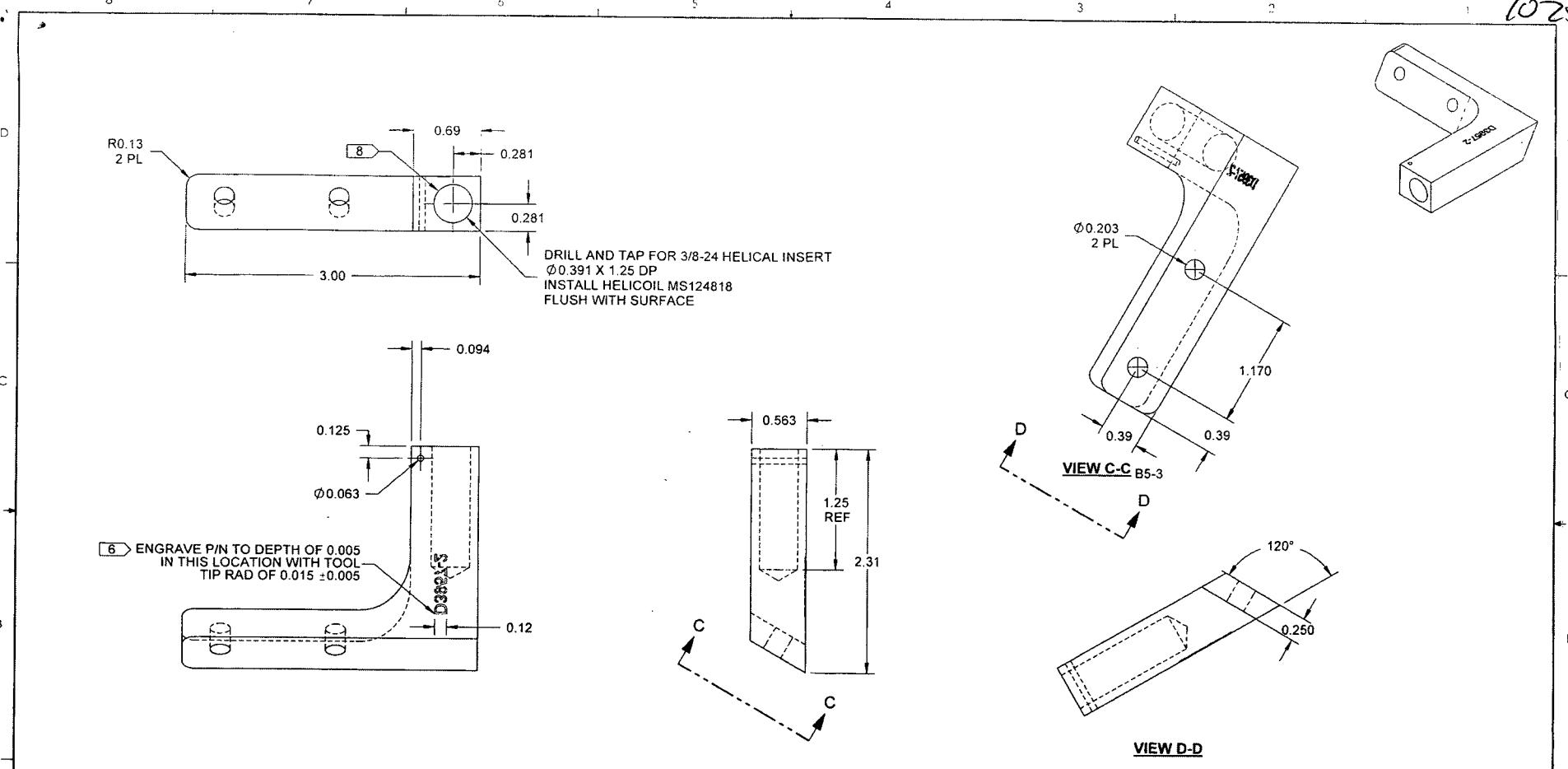
Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
NCR No. _____									

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
Bending	Bend	Folio/Program	Outside Dimensions			Pressure/Forced			
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance			Set-up			
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect			Temperature/Cure			
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing			Weld			
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved			Wrong Stock Pulled			
Crushing	Countersink	Misaligned/off center	Positioned Wrong			Power Loss/Surge			
Heat Treat	Cut Too Short	Mislabeled	Other						
Inspection Strip in Tube	Drawing	Misread							
Marks/Chatter	Drill Holes	Off-set							
Turning Sequence	Finish	Out of Calibration							
Wave/Twist in Tube	Fit/Function	Out of Sequence							

10250



**D3957-2 HINGE, DOOR RH UPPER**

## NOTES

1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQA-225B (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQA-200B (OR AMS 4160)  
REF DART SPEC M6061T6B

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE P/N AS SHOWN

7) WEIGHT: 0.10 lbs

8) MASK HOLE PRIOR TO POWDER COAT

C3-3

RELEASED  
2009-10-08

DESIGN	<i>AB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>AB</i>			
CHECKED	<i>PH</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>SH</i>	D3957	SHEET 3 OF	
APPROVED	<i>WJF</i>	TITLE	SCALE	
DE APPR.	<i>SH</i>	HINGE	INTL	
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## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

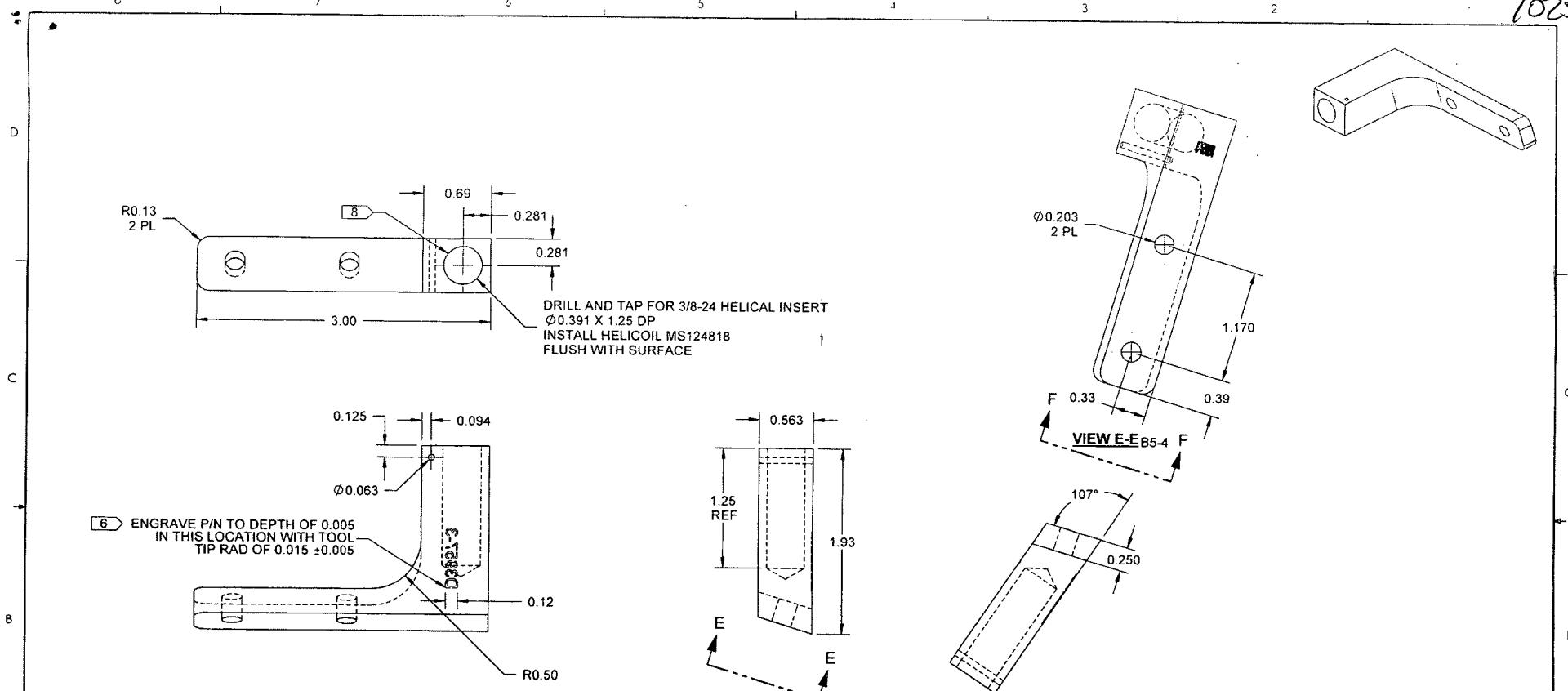
Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
NCR No. _____									

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear	General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
Crushing	Countersink	Misaligned/off center	Positioned Wrong						
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge						
Inspection Strip in Tube	Drawing	Misread							
Marks/Chatter	Drill Holes	Off-set							
Turning Sequence	Finish	Out of Calibration							
Wave/Twist in Tube	Fit/Function	Out of Sequence							

102550



## NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

D3957-3 HINGE, DOOR LH LOWER

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>AS</i>	DRAWING NO.
MFG. APPR.	<i>AS</i>	REV. A
APPROVED	<i>AS</i>	D3957 SHEET 4 OF 5
DE APPR.	<i>AS</i>	TITLE
DATE	09.09.03	SCALE
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2009-10-08  
*MAP*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_

Date: \_\_\_\_\_

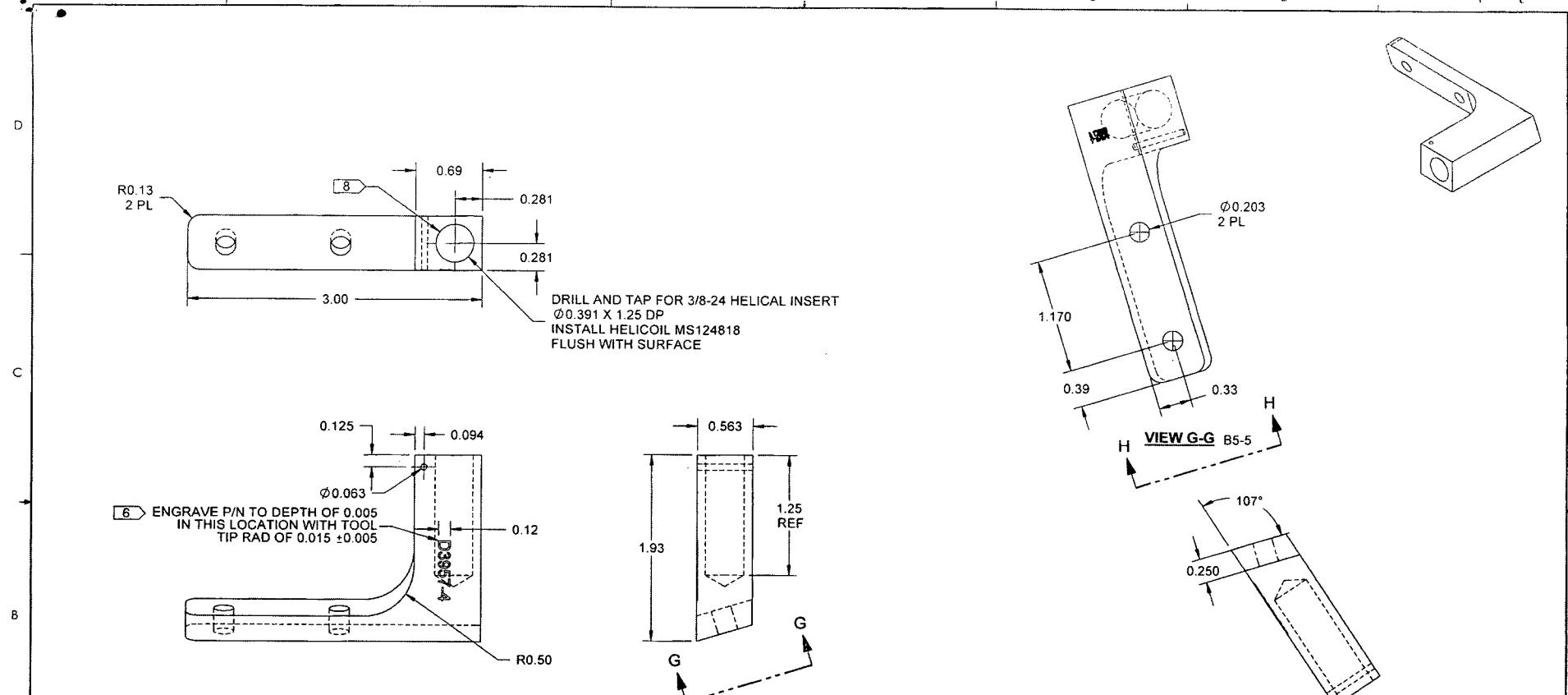
Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General	Folio/Program	Outside Dimensions	Pressure/Forced
Bending	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Crushing	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>		
Inspection Strip in Tube	Drawing <input type="checkbox"/>	Off-set <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>			



D3957-4 HINGE, DOOR RH LOWER

## NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>AS</i>	DART AEROSPACE LTD
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>PH</i>	DRAWING NO.
MFG. APPR.	<i>PH</i>	REV. A
APPROVED	<i>AS</i>	D3957
DE APPR.	<i>AS</i>	SHEET 5 OF 5
DATE	09.09.03	SCALE
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DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Date:



# WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## Work Order update only